

NOT RELEVANT Split Ship Tomorrow

Order ID 90781-2

25-12 7:31:48 AM

90781

Item ID: D3650-3

Revision ID:

Item Name: Center Panel

Start Date: 9/25/12

Required Date: 9/27/12

Reference:

Start Qty: 6.00

Req'd Qty: 6.00

Approvals:

Process Plan:

QC:

Date:

Date:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Draw Nbr

D3650

100

100

Waterjet

FLOW CNC Waterjet

304, 240"

Operation
Description

Revision Nbr

Rev D

FLOW WATER JET

Memo

1-Cut as per Dwg D3650

Dwg Rev:

Prog Rev: Custom

2-Deburr if necessary

Tooling:

SPC (Y/N):

Set Up/
Run Hours

0.00

0.00

0.00

0.00

Date:

Date:

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

6 c

Jan 17-9-25

6 c

Jan 17-9-25

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Work Order ID 90781

September-25-12 7:31:48 AM

90781

Page 2

Item ID: D3650-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Center Panel

Start Date: 9/25/12

Start Qty: 6.00

6

Cust Item ID:

Required Date: 9/27/12

Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

5mb

0.00

12.9.26

6

120

QC

Memo

Quality Control

130

NC BRAKE

0.00

130

Brake NC

Memo

0.00

Brake NC

1-Form as per Dwg D3650 using DT9426

2-bend as per dwg

3

12-10-02

SB
12/09/26

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

5mb
12-10-02
17/10/02

DAS
16

3

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: *[Signature]*

Date: 12/10/15

QA Closed: *[Signature]*

Date: 12/10/15

Work Order: <u>90781</u> Part No. <u>D3650-3</u> NCR No. <u>12-1901</u>				DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input checked="" type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
---	--	--	--	--	--	--	--	--	--	--	--

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>	12/10/15	130	2	2 part were scrap because prototype and had to try for the new jig this fit	DAS 12 2-13 12/10/15	Scrap & destroy No replace 62.34 x 2 = \$124.68	SB 12/10/15	 12/10/15	 12/10/15
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other

First Time was made + had to try new jigs

133

134

135

Work Order ID 90781

90781

Page 3

September-25-12 7:31:48 AM

Item ID: D3650-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Center Panel

Start Date: 9/25/12

Start Qty: 6.00

6

Cust Item ID:

Required Date: 9/27/12

Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

160

Large Fab

Large Fab

Large Fab

Memo

1-trim to fit (D3650-1/1)

2-Weld assembly as per dwg D3650 QSI004

3-grind weld smooth if necessary

0.00

0.00

170

170

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

N/A

12.10.02

Work Order ID 90781

September-25-12 7:31:48 AM

90781

Page 4

Item ID: D3650-3

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Center Panel

Stop *NS2*

Start Date: 9/25/12 Start Qty: 6.00 *6*

Required Date: 9/27/12 Req'd Qty: 6.00 *6*

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

190

Identify as per dwg & Stock Location: GA

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

Handwritten: 1290388

Handwritten: 12/10/5

Handwritten: 12-10-02

Picklist Print

September-25-12 7:31:47 AM

Page 1

Work Order ID: 90781

Parent Item: D3650-3

Parent Item Name: Center Panel

Start Date: 9/25/12

Required Date: 9/27/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3650-11 Filler Plate		Manufactured	No			160	Each	5.0000	1	6			

Location

Loc Qty

Loc Code

WA021

5

45721

5

M304S26GA

304/316 0.018 SHEET

Purchased

No

160

sf

418.5600

1.145

7.2345789

7.5 S-F

Jim
12-9-15

Location

Loc Qty

Loc Code

MAT020

418.56

417798

35.06

422753

127.5

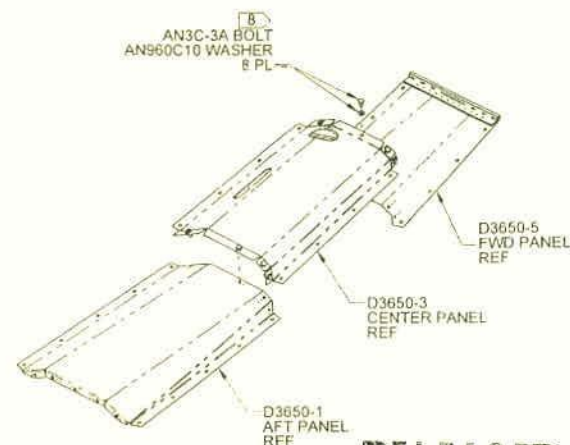
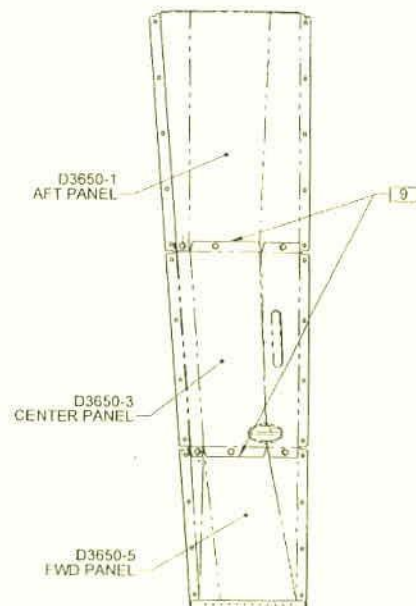
423135

256

122732

122732

QTY -041	PART NUMBER	DESCRIPTION
X	D3650-041	TUNNEL TOP PANEL ASSEMBLY
1	D3650-1	AFT PANEL
1	D3650-3	CENTER PANEL
1	D3650-5	FWD PANEL
8	AN3C-3A	BOLT
8	AN960C10	WASHER



RELEASED
2012-08-24

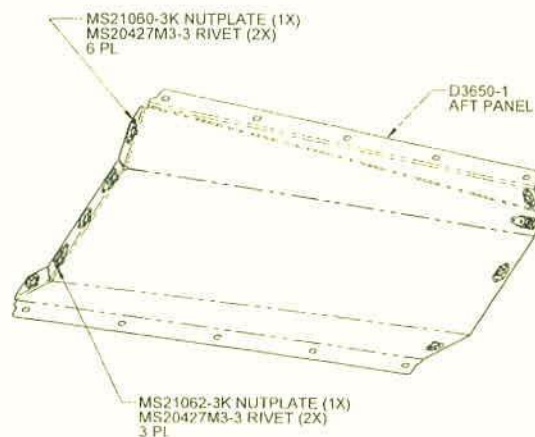
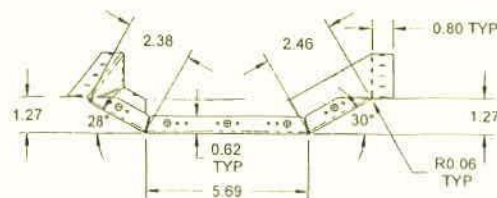
D3650-041 TUNNEL TOP PANEL ASSEMBLY

NOTES

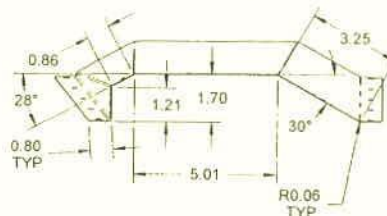
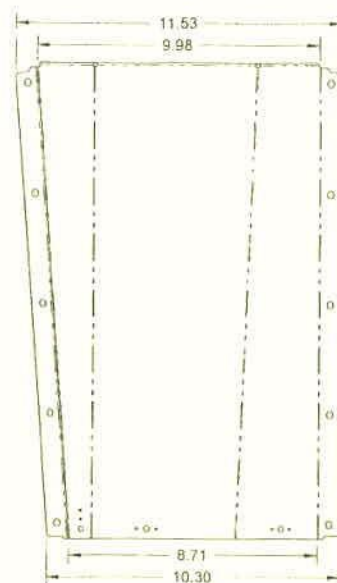
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.3 lbs
- 8) TORQUE FASTENERS: 15 TO 25 in-lb
- 9) SEAL: ALL-MATING SURFACES AND ALL GAPS USING PROSEAL 700 FIRE WALL SEALANT

D	D3650-11 REPLACED WITH AN EMBOSS. PAGE 4 DELETED. D3650-3 BEND REFLECTS CHANGED TO TRIANGULAR SHAPE AT BOTH ENDS. D3650-3 HOLES CHANGED TO SLOTS. ALL NOTES UPDATED TO CONFORM TO QSI 018. TIGHTER CUT TOLERANCES IN ALL FLAT PATTERNS. ADDED: 0.0008 HOLES 12 PLACES (C7-7). D.E.O. D3650-C-1 INCORPORATED.	RP	12 08 12
C	REFORMATTED TO NEW STANDARDS. RELOCATED PART LIST (ZN D2-2). ADDED SECTION VIEW J-J & REVISE DIMENSIONS (ZN B7-5, C4-5). ADDED RECESS LOCATION & REVISED DIMENSIONS (ZN C6-6, D5-6). MS20615-4MS WAS CR3523-4.03 & NAS1149CN432R WAS AN960C4 (ZN D5-7, B5-7, B8-7).	RF	08 10 14
B	SHEETS 1, 2 & 7 UPDATED FASTENER QUANTITIES. UPDATED VIEWS. SHEETS 3 & 8 REMOVED/RELOCATED HOLES. UPDATED VIEWS. SHEET 4, 1 & 5 WAS 1.5, 1.0 WAS 0.8, UPDATED VIEW. ADDED NOTE 8. SHEET 5: REMOVED NOTE IN C6 & ASSOCIATED DIMS. UPDATED VIEWS. SHEET 6: REMOVED/RELOCATED HOLES & ADDED. CUTOUT TO D3650-3F. MOVED D3650-11/11F TO SHEET 9. ADDED DETAIL 1. SHEET 9: RELOCATED D3650-11/11F FROM SHEET 6. UPDATED DIMS OF D3650-11/11F.	RF	08 01 07
A	NEW ISSUE	RF	07 11 07
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR		D3650	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR		TOP PANEL ASSEMBLY	NTS
DATE	12.08.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	

QTY -1	PART NUMBER	DESCRIPTION
X	D3650-1	AFT PANEL
1	D3650-1B	AFT PANEL BENT PART
18	MS20427M3-3	RIVET
6	MS21060-3K	NUTPLATE
3	MS21062-3K	NUT PLATE



D3650-1 AFT PANEL



D3650-1B AFT PANEL BENT PART

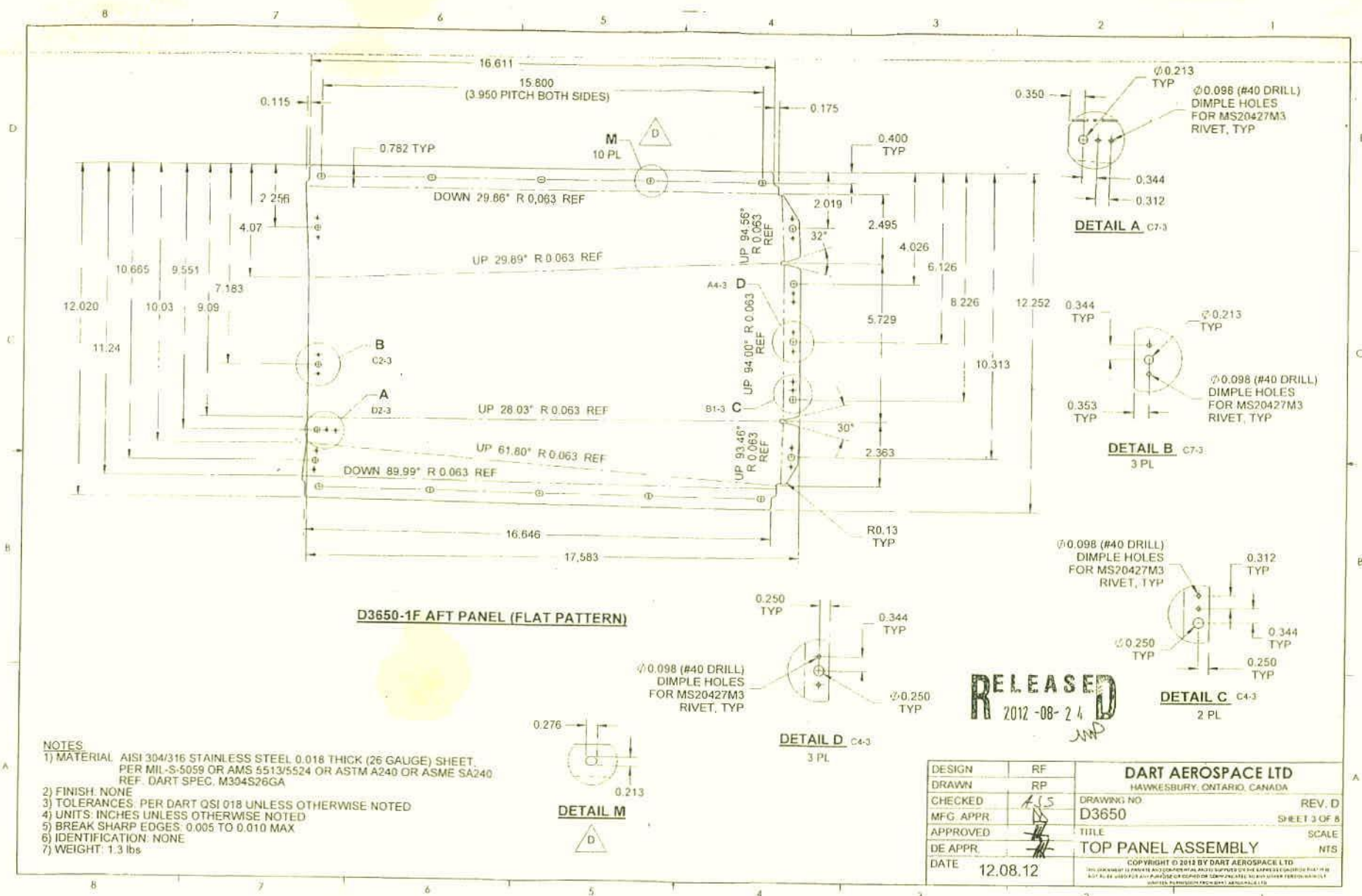


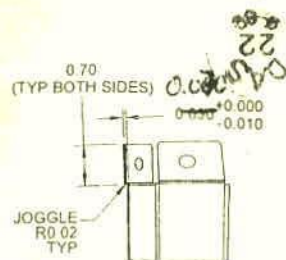
RELEASED
2012-08-24

NOTES:

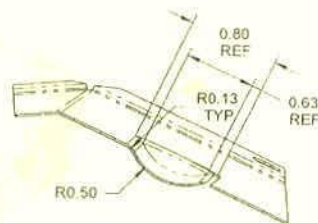
- 1) MATERIAL: MAKE FROM D3650-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.3 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO. D3650	REV. D
MFG. APPR.		SHEET 2 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	12.08.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD	

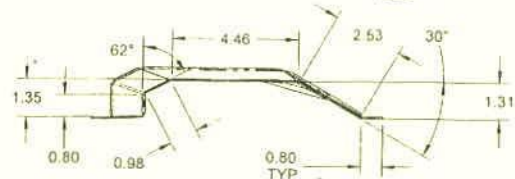
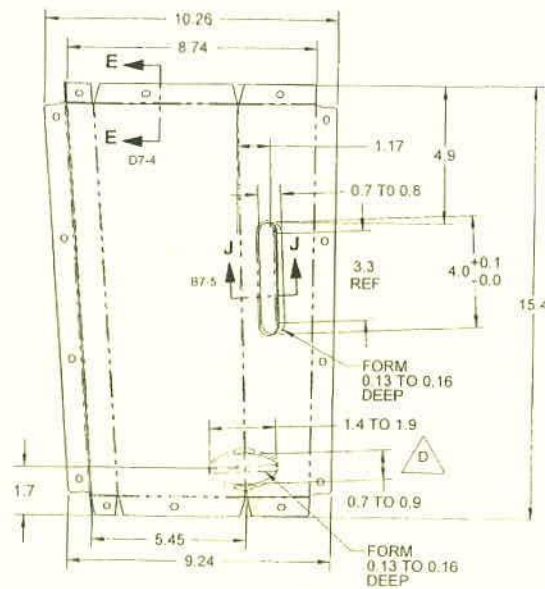
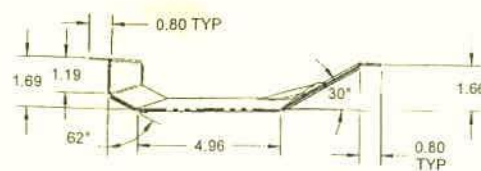




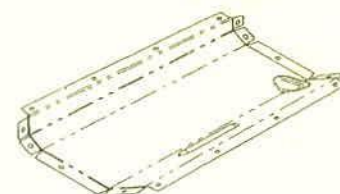
SECTION E-E C5.4



SECTION J-J C4.4



D3650-3 CENTER PANEL



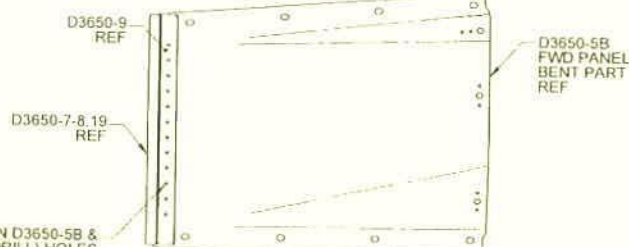
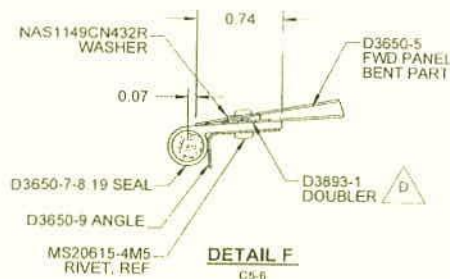
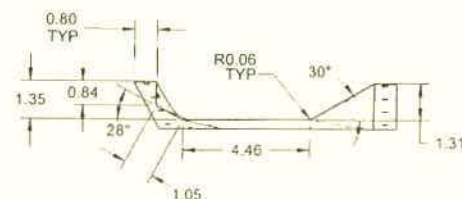
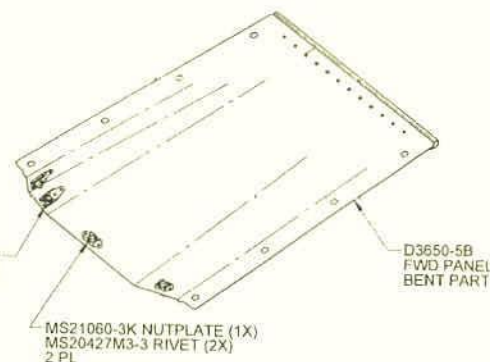
RELEASED
2012-08-24
JND

- NOTES:
- 1) MATERIAL: MAKE FROM D3650-3F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES, 0.005 TO 0.010 MAX.
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.98 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. D
MFG APPR	N	D3650	SHEET 4 OF 8
APPROVED	N	TITLE	SCALE
DE APPR	N	TOP PANEL ASSEMBLY	NTS
DATE	12.08.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS UNCLASSIFIED AND NOT FOR RELEASE TO THE PUBLIC WITHOUT THE EXPRESS WRITTEN PERMISSION OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE EXPRESS WRITTEN PERMISSION OF DART AEROSPACE LTD.			

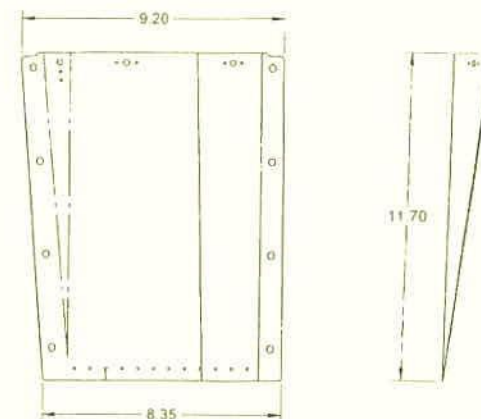
QTY -5	PART NUMBER	DESCRIPTION
X	D3650-5	FWD PANEL
1	D3650-5B	FWD PANEL BENT PART
1	D3650-7-8 19	SEAL
1	D3650-9	ANGLE
1	D3893-1	DOUBLER
12	NAS1149CN432R	WASHER
12	MS20615-4M5	RIVET
8	MS20427M3-3	RIVET
2	MS21060-3K	NUTPLATE
2	MS21062-3K	NUTPLATE

MS21062-3K NUTPLATE (1X)
MS20427M3-3 RIVET (2X)
2 PL



CENTRE D3650-7-9 ON D3650-5B &
TRANSFER Ø0.129 (#30 DRILL) HOLES
FROM D3650-9 TO D3650-7 & D3650-5B
AS SHOWN
INSTALL
MS20615-4M5 RIVET
NAS1149CN432R WASHER
12 PL

D3650-5 FWD PANEL



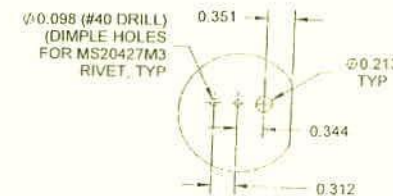
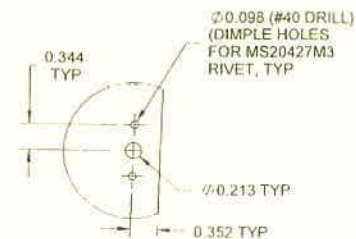
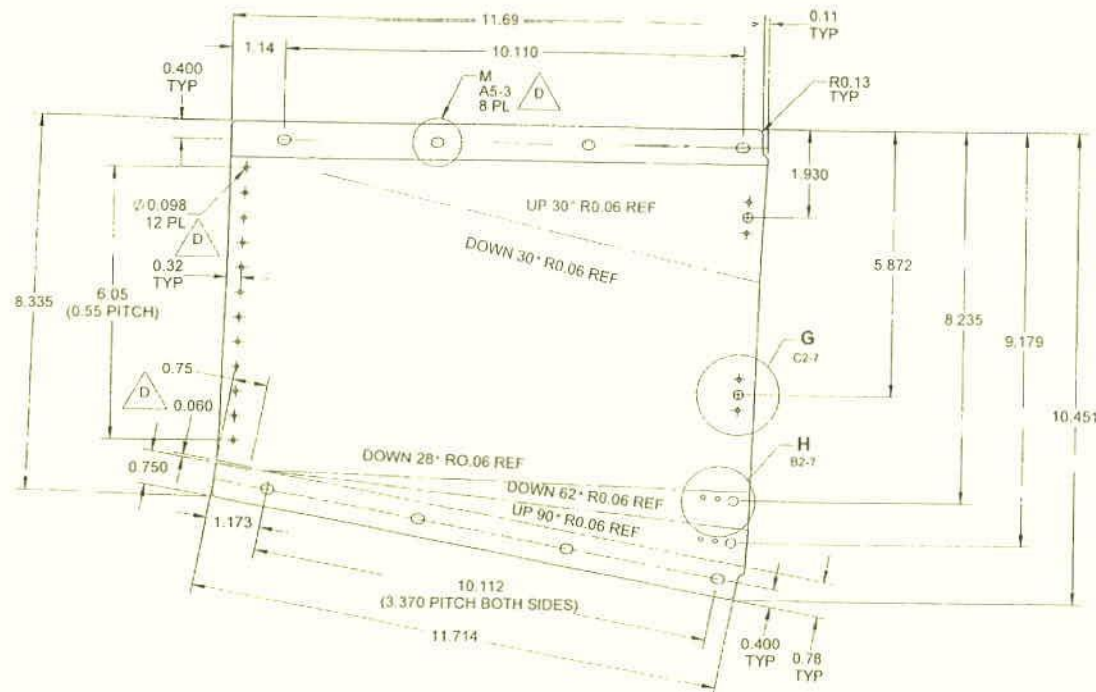
D3650-5B FWD PANEL BENT PART

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2012-08-24

NOTES

- 1) MATERIAL: MAKE FROM D3650-5F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.8 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.		D3650	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	12.08.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD	



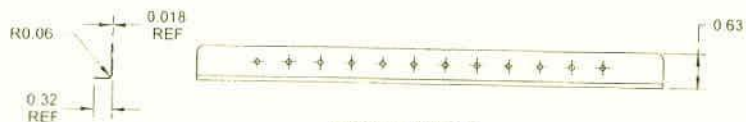
D3650-5F FWD PANEL (FLAT PATTERN)

NOTES

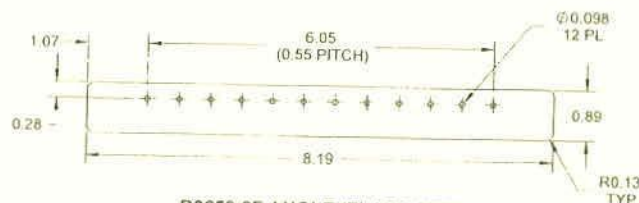
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF. DART SPEC. M304S26GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

RELEASED
2012-08-24

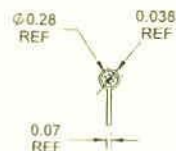
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DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. D3650	REV. D
MFG. APPR	NS	TITLE	SHEET 7 OF 8
APPROVED	NS	TOP PANEL ASSEMBLY	SCALE
DE APPR	NS		NTS
DATE	12.08.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD	



D3650-9 ANGLE
(MAKE FROM D3650-9F)



D3650-9F ANGLE (FLAT PATTERN)



D3650-7-8.19 SEAL

NOTES

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

D3650-9F

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S26GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb

RELEASED
2012-08-24

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO. D3650	REV. D
MFG. APPR.			SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	12.08.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD	

DART AEROSPACE LTD		Work Order: 90781
Description: Center Panel Custom		Part Number: D3650-3 Custom
Inspection Dwg: D3650	Rev: D- Custom	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.166"	±0.010"	10.166"	-		V	
10.655"	±0.010"	10.653"	-		V	
11.266"	±0.010"	11.269"	-		V	
12.097"	±0.010"	12.097"	-		T	
0.350"	±0.010"	0.355"	-		V	
0.680"	±0.010"	0.676"	-		V	
13.80"	±0.030"	13.80"	-		T	
15.57"	±0.030"	15.57"	-		T	
0.16"	±0.030"				V	
0.847"	±0.010"	0.847"	-		V	
1.947"	±0.010"	1.949"	-		V	
3.136"	±0.010"	3.136"	-		V	
3.558"	±0.010"	3.558"	-		V	
5.894"	±0.010"	5.896"	-		V	
7.646"	±0.010"	7.646"	-		V	
8.262"	±0.010"	8.265"	-		V	
8.724"	±0.010"	8.724"	-		V	
9.187"	±0.010"	9.189"	-		V	
9.491"	±0.010"	9.491"	-		V	
10.509"	±0.010"	10.509"	-		V	
0.040"	±0.010"	0.034"	-		V	

Measured by: Jm	Audited by: Smb	Preliminary Approval:
Date: 12-9-25	Date: 12-9-26	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD		Work Order:	90781
Description: Center Panel - Custom		Part Number:	1236503 (Custom)
Inspection Dwg: D3650 Rev: D Custom (0.040)		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	0.276"	± 0.010"	0.277"	-		✓	MM101
	0.213"	± 0.010"	0.214"	-		✓	
	15.47"	± 0.030"	15.47"	-		T	MM301
	13.750"	± 0.010"	13.750"	-		T	
	12.900"	± 0.010"	12.900"	-		T	
Bend	0.14"	± 0.030"				✓	
	0.84"	± 0.030"	0.840"	-		✓	
	0.400"	± 0.010"	0.400"	-		✓	
?	2.31"	± 0.030"				✓	
?	3.296"	± 0.010"				✓	
?	1.32"	± 0.030"				✓	
?	2.13"	± 0.030"				✓	
Bend	0.782"	± 0.010"				✓	
Bend	0.08"	± 0.030"				✓	
Bend	0.782"	± 0.010"				✓	
	0.840"	± 0.010"	0.840"	-		✓	
	2.256"	± 0.010"	2.253"	-		✓	
	3.750"	± 0.010"	3.750"	-		✓	
	4.173"	± 0.010"	4.173"	-		✓	
	7.220"	± 0.010"	7.215"	-		✓	
	8.827"	± 0.010"	8.827"	-		✓	Printer Jet
	9.567"	± 0.010"	9.566"	-		✓	
	10.090"	± 0.010"	10.080"	-		✓	

Measured by: JM	Audited by: SM	Preliminary Approval:
Date: 12-9-25	Date: D.A.25	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		